

Split

Page 1

Work Order ID 56795-2



March 10, 2010 11:55:34 AM

Item ID: D2011-101

Accept



Setup Start



Revision ID:

Stop



Item Name: 6" Mirror

40



Cust Item ID:

Start Date: 3/10/10 Start Qty: 50.00

Customer:



Required Date: 3/16/10 Req'd Qty: 50.00



Reference:

Run Start



Approvals:

Process Plan: CL

Date: 10/3/10 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

D2011

Revision Nbr

Rev G

0.00

100



Purchasing

Purchasing

PURCHASING

0.00

CL 10/3/10

50

Memo

Issue P/O: 11489 | Mirror P/N: CHM10601 | Possible supplier:
Auto Parts Extra! Material release note required

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

CL 10/3/11

50

Memo

Ensure material certification is attached

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

5/10/10

Counts

+33

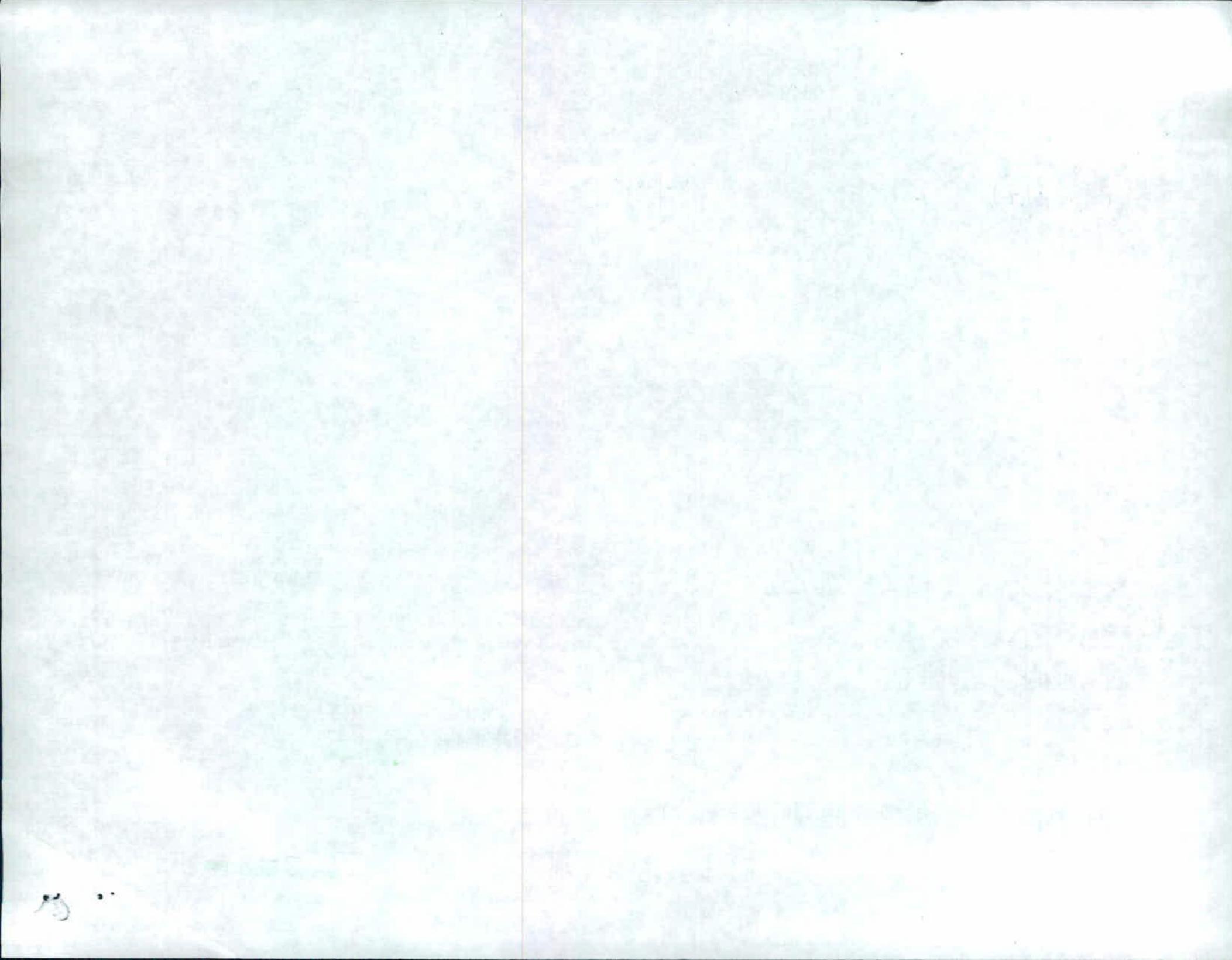
+41

Pb →

Memo

0.00

24



WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: D2011-101 PAR #: Fault Category: Supplier NCR: Yes No DQA: J Date: 1004.08
 Resolution: SCRW Disposition: return to supplier QA: N/C Closed: HJ Date: 10/07/21

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/12	# 120	During inspection Found QTY x1 mirror fell apart apart in the original package from supplier. PC Defect: No taper on the	J ASUR	→ inform supplier of issue and ask for Refund or credit + Return Defective mirror back.	10/03/12	S 10/03/30	J 10/03/12	S 10/03/12
		Backing circumference	J ASUR	- Pull test each mirror to SOLSS to ensure remainder is good.	10/03/12	S 10/03/30	J 10/03/12	S 10/03/15
			J ASUR	During Pull test test QTY x4 mirrors Pulled Apart Re inform supplier of issue	10/03/30	S 10/03/30	J 10/03/30	S 10/03/30

NOTE: Date & initial all entries

Work Order ID 56795 - 2

March 10, 2010 11:55:34 AM



Item ID: D2011-101

Accept



Setup Start



Revision ID:

Stop



Item Name: 6" Mirror

Start Date: 3/10/10 Start Qty: 50.00



Cust Item ID:

Required Date: 3/16/10 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

- 1- Wrap mirror with plastic wrap
- 2- Discard Hardware & Install new hardware loosely
- 3- Crimp stud as per Dwg D2011

140



QC

Quality Control

QCS- Inspect part completeness to step on W/O

0.00

Sw/03/30

cucular
(x33)

x2

150



Packaging

Memo

0.00

Identify as per dwg & Stock Location: ST232 0.00

CY10/3/31 X 31

Packaging

33x
PTO →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2011-101 PAR #: _____ Fault Category: Small Fabs NCR: Yes No DQA: *J* Date: 100408
 Resolution: scrap Disposition: scrap QA: N/C Closed: *J* Date: 10/07/21

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/20	# 130	two mirrors Found with markings /scratches on them	<i>J</i> AS/UNL	-Scrap + Destroy 2ty & Z - Ensure mirrors are well protected & verified after each activity.	S 10/03/20	PD 10.03.20	<i>J</i> AS/UNL	S 10/03/20

NOTE: Date & initial all entries

Work Order ID 56795

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March 10, 2010 11:55:34 AM

Item ID: D2011-101

Accept



Setup Start



Revision ID:

Stop



Item Name: 6" Mirror

Start Date: 3/10/10 Start Qty: 50.00



Cust Item ID:

Required Date: 3/16/10 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

Memo

0.00

10/04/07 HJ

MF
10-4-6



Picklist Print

Page 1

March 10, 2010 11:55:34 AM

Work Order ID: 56795



Parent Item: D2011-101



Parent Item Name: 6" Mirror

Start Date: 3/10/10

Required Date: 3/16/10

Comments: IPP: J 04.09.15 Added Steps 5-7
K 05.12.15 chg black sikaflex for white EC IPP L 08.11.06 new
drawing EC verify: DD IPP: M 08.12.19 Added step 3 KJ Verified
by: LI. IPP rev N 10.01.13 added wrap per ncr09-118 EC verified by:DD

Start Qty: 50.00

Required Qty: 50.00

AN960JD416L



Purchased No

110

Each

653.0000 50.0000



Washer

QSI WASI147D0416]

M114056 ~~33X~~ 33Y

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST346	653	
105078	4	
107008	54	
108583	35	
110153	160	
112492	400	

EP 0/03/30

CHM-10601



Purchased No

130

0.0000 50.0000

33X



Mirror 6"

D2829



Threaded Stud

Manufactured No

130

24.0000 50.0000

EP 0/03/30

EP 0/03/30

Warehouse	Loc Qty	Loc Code
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Location

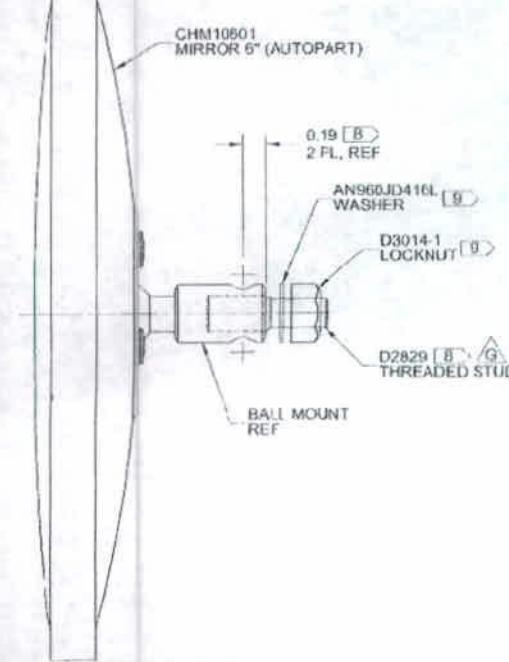
Main Warehouse

ST25	24	
54930	24	

~~12~~ 12X

B56986 ~~20X~~ 20X

ITEM	QTY -101	QTY -103	P/N	DESCRIPTION
1	X		D2011-101	MIRROR ASSEMBLY 6"
2		X	D2011-103	MIRROR ASSEMBLY 8"
3	1		D2829	THREADED STUD
4	1		D3014-1	LOCKNUT
5		1	D3015-3	LOCKNUT
6	1		CHM10601	MIRROR 6" (AUTOPART)
7		1	708441	MIRROR 8" (VELVAC)
8	1		AN980JD416L	WASHER
9		1	AN980JD516	WASHER

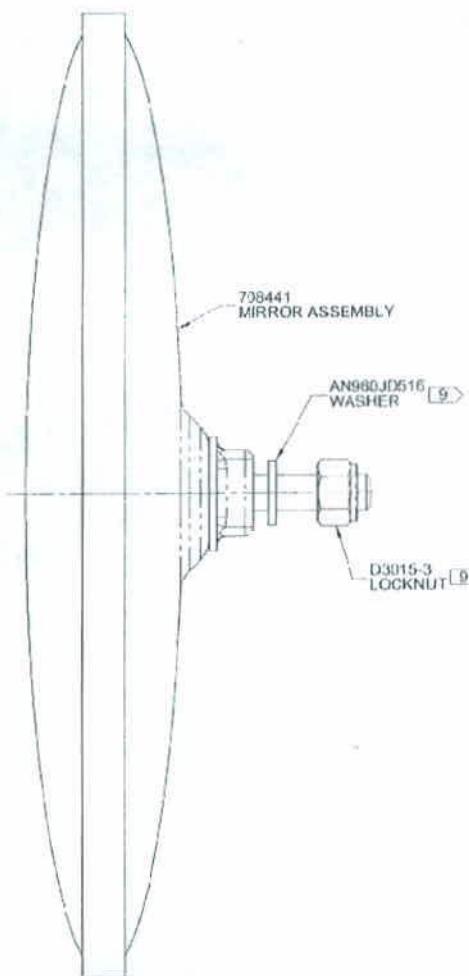


D2011-101 MIRROR ASSEMBLY 6"

CK10/3110

W10: 56 715

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNIT'S: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: D2011-101 = 0.6 lbs APPROX. , D2011-103 = 1.0 lbs APPROX.
 8) D2829 INSTALLATION PROCEDURE:
 - APPLY LOCKTITE 262 TO Ø5/16 END OF D2829
 - THREAD BY HAND INTO BALL MOUNT UNTIL ENTIRE Ø5/16 END OF D2829 IS WITHIN BALL MOUNT
 - CRIMP BALL MOUNT ON TWO OPPPOSING SIDES, 0.13 FROM END AS ILLUSTRATED USING TOOL DTB317
 - CRIMP TO DEPTH OF 0.040 ± 0.010 USING RD.125
 9) INSTALL LOOSE



D2011-103 MIRROR ASSEMBLY 8"

RELEASED
 CK 10/20/06

G	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE DRAWING. THE MIRROR WAS 6" (CHM10601) AND 8" (708441). THE STUDS WERE MIRROR 6" (GROTE) AND PIN 3803 (2H D3-1). ADDED D2829 (2H D3-1 AND 7N G6.13). REMOVED DRILLING NOTE, VIEW A-A AND SIKAFLEX APPLICATION NOTE. REASON: GROTE PRODUCT IS DISCONTINUED.	MB	08/06/06
F	ADD HOLES FOR SEALANT ON -101	CP	04/09/10
E	NEW 8" MIRROR	CP	01/05/08
D	NEW 6" MIRROR, ADD NUT, REMOVED STUD	CP	01/04/03
C	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	RF	09/06/01
B	SIKAFLEX 241 ADDED	JB	08/04/09
A	DW10 NO. WAS DSP1011, ADDED -103	JB	00/06/15
-	NFW ISSUE	JB	00/03/31
REV:	DESCRIPTION	BY	DATE

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV G	
DRAWING NO.		REV G	
D2011		SHEET 1 OF 1	
APPROVED		TITLE	SCALE
DE APPR.		MIRROR ASSEMBLY	NTS
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